

Date: Friday, 01/08/2008 3:32:47 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BACKER PLATE
Job Number :	40984		
Estimate Number :	13538		
P.O. Number :		Part Number :	D31913
This Issue :	01/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3191 REVA
First Issue :	/ /	Project Number :	N/A
Previous Run :		Drawing Revision :	A
	Type :	Material :	
	SMALL /MED FAB	Due Date :	30/08/2008
Written By :		Qty:	5
Checked & Approved By :	<u>JD 08.8.05</u>	Um:	Each
Comment :	Est Rev:A 08-08-01 new issue DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M6061T6S063	6061-T6 .063 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.1355 sf(s)/Unit Total: 0.6773 sf(s)
 6061-T6 .063 Sheet
 batch: 108279 B 8-8-13

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3191
 Dwg Rev: A
 Prog Rev: A

B 8-8-136

2-Deburr if necessary

B 8-8-13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

B 8-8-13**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK8 08/08/13 (x6)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------

(6x)

Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

m-a 08/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 3:32:47 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACKER PLATE

Job Number: 40984

Part Number: D31913

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M1106442



(6X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:20
3:20
3:50

m-h 08/08/13

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



42



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-13

(6X)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(6X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 75

8/8/14

Slp

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

08/08/15

Job Completion



mf 08-08-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

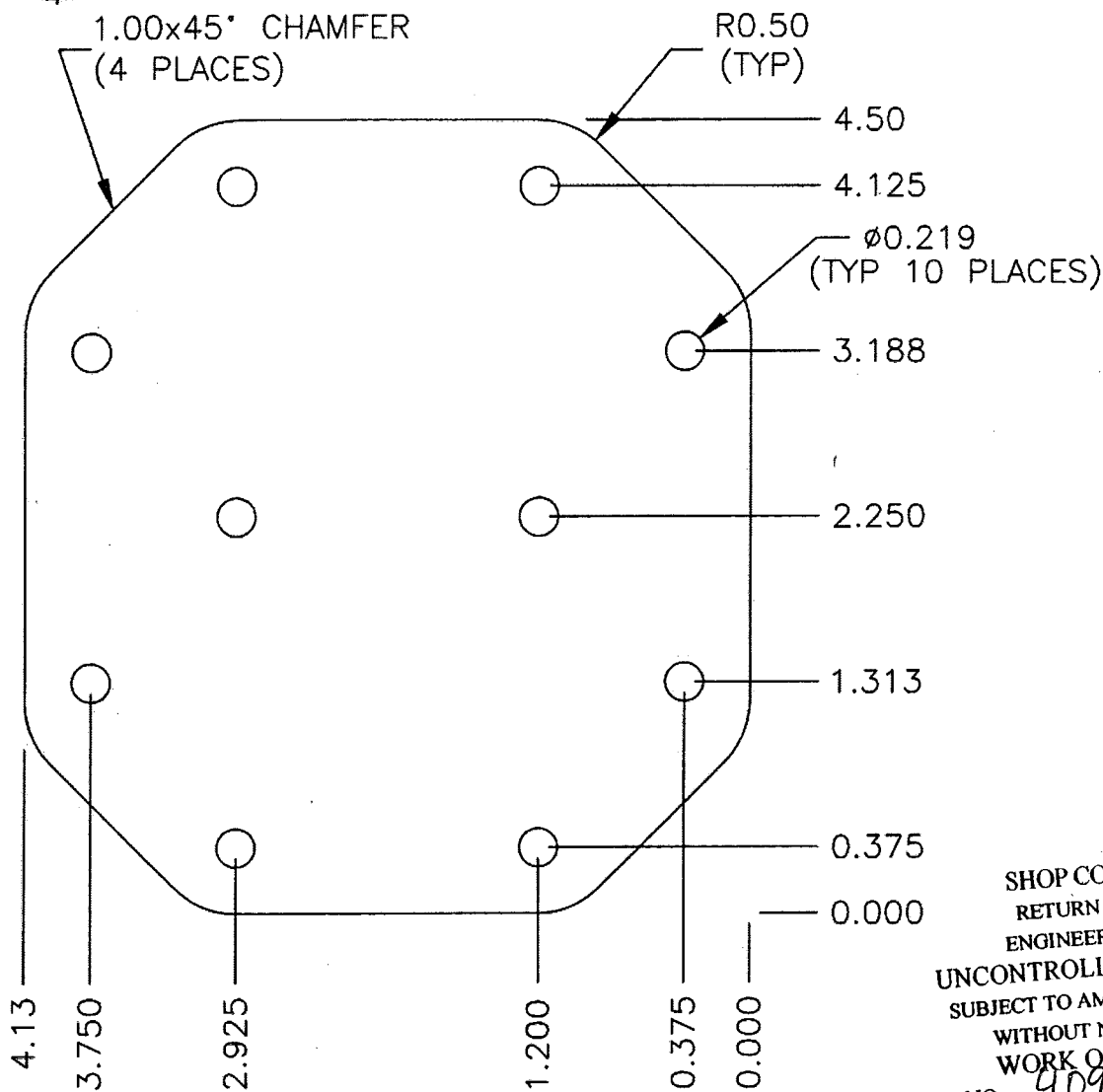
NOTE: Date & initial all entries





DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3191	REV. A SHEET 2 OF 2
DATE 03.05.27		TITLE BACKER PLATE	SCALE 1:1

RELEASED
03.07.09



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40989

D3191-3 BACKER PLATE

- 1) MATERIAL: 6061-T6 (QQ-A-250/11), 0.063 THICK (REF DART SPEC. M6061T6S.063)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

